

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011900**Date Inspected:** 13-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6AW

This Quality Assurance (QA) Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Segment 6AW (Bottom panel hold back weld) the welds Designation are as follows.

BP86-001-034~039, BP140-001-038~041

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

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OBG SEGMENT 6BW-6CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066179, 037743 performing Shielded Metal Arc Welding process for weld OBW6A-003 located on PCMK bottom panel splice weld between OBG segment 6BW-6CW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) –FCM-Repair-1. Critical weld repair report identified as B-CWR1209.

OBG SEGMENT 6BW

This Quality Assurance (QA) Inspector observed ABF Inspector performing Ultrasonic Inspection on the corner weld between deck panel and edge panel (counter weight side) of OBG segment 6BW.

ULTRASONIC INSPECTION

American Bridge Fluor (ABF) request number: 02122010-1.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. The QA Inspector observed Rejectable indications during the time of testing.

Weld identification numbers were

CA018-002, 004, 006 (OBG 5AE-DP to EP-E2)

OBE6C-005 (OBG 5CE-B.P to SP-E3)

SEG-026A-008 (OBG 6BE/6CE S.P- C5)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

ABF Inspector performing Ultrasonic Inspection on the corner weld between deck panel and edge panel of OBG segment 6BW (counter weight side)



ZPMC welders 066179, 037743 performing SMAW welding on the bottom panel splice weld between OBG segment 6BW and 6CW.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Dawson,Paul
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QA Reviewer
